

Date: Tuesday, 7/17/2007 2:00:28 PM
 User: Kim Johnston

Process Sheet

8/21/07
WP
8/21/07/27

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BRACKET ASSEMBLY
 Job Number : 33589
 Estimate Number : 11030
 P.O. Number : *NIA* Part Number : D2803042
 This Issue : 7/17/2007 S.O. No. : *NIA* Drawing Number : D2803 REV B
 Prsht Rev. : NC Project Number : N/A
 First Issue : *NIA* Type : PURCHASED PARTS Drawing Revision : B
 Previous Run : 29392 Material : *NIA*
 Written By : Due Date : 7/31/2007 Qty: 10 Um: Each
 Checked & Approved By : *07.07.17*
 Comment : Est F 05:03.30 MS21043-3 was MS21042L3 KJ/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D28032 STA 84 Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
 STA 84 BRACKET

Pick:

Qty Part Number Description
 1 D2803-2 Bracket

Batch

B33599 x 10

2.0 D28052 Stop



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
 STOP

Pick:

Qty Part Number Description Batch
 1 D2805-2 Stop

B33600 / B34033 (x10)

3.0 D2809 Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
 Bushing

Pick:

Qty Part Number Description Batch
 1 D2809 Bushing

B30749

PHO

4.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Press D2805-2 into arm as per Dwg D2803

SAO 07/09/16
ml 07/08/07 x10

| W/O: | | WORK ORDER CHANGES | | | | | | |
|----------|------|---|----|----------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| 07/08/28 | 30 | Max Step change Step 30 is to be in front of Step # 8.0 | | | | | Sp H/08/28 | |
| 07/08/29 | 5 | split w/o white | SD | 07/08/29 | 3 | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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NOTE: Date & initial all entries

Date: Tuesday, 7/17/2007 2:00:28 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 33589

Part Number: D2803042

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/08/28 (+10)

6.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

7 pcs - green sandtex
3 pcs - white M1105068

7x green
3x white

M-1 07/08/29

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SAD 07/09/16

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Press D2809 into arm as per Dwg D2803

SAD 07/09/16

9.0

AN3C16A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Bolt

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|-------|
| 2 | AN3C16A | Bolt | |

M101884

SP

10.0

MS210433

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Nut

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|-------|
| 2 | MS21043-3 | Nut | |

M104955

SP

11.0

NAS1515H3

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Washer

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|-------|
| 4 | NAS1515H3 | Washer | |

M100993

SP

A/R LPS-3

Corrosion Spray

M104929 SAD 07/09/16

7/8/29 SP

Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2803

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: LD Date: 07/09/19
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 33589

Part Number: D2803042

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble as per Dwg D2803.

SAN 07/09/16

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SA 07/09/17 (3)

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: 52150

SA 07/09/17 (3)

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(3)
20709/19

Job Completion



11 0709-18

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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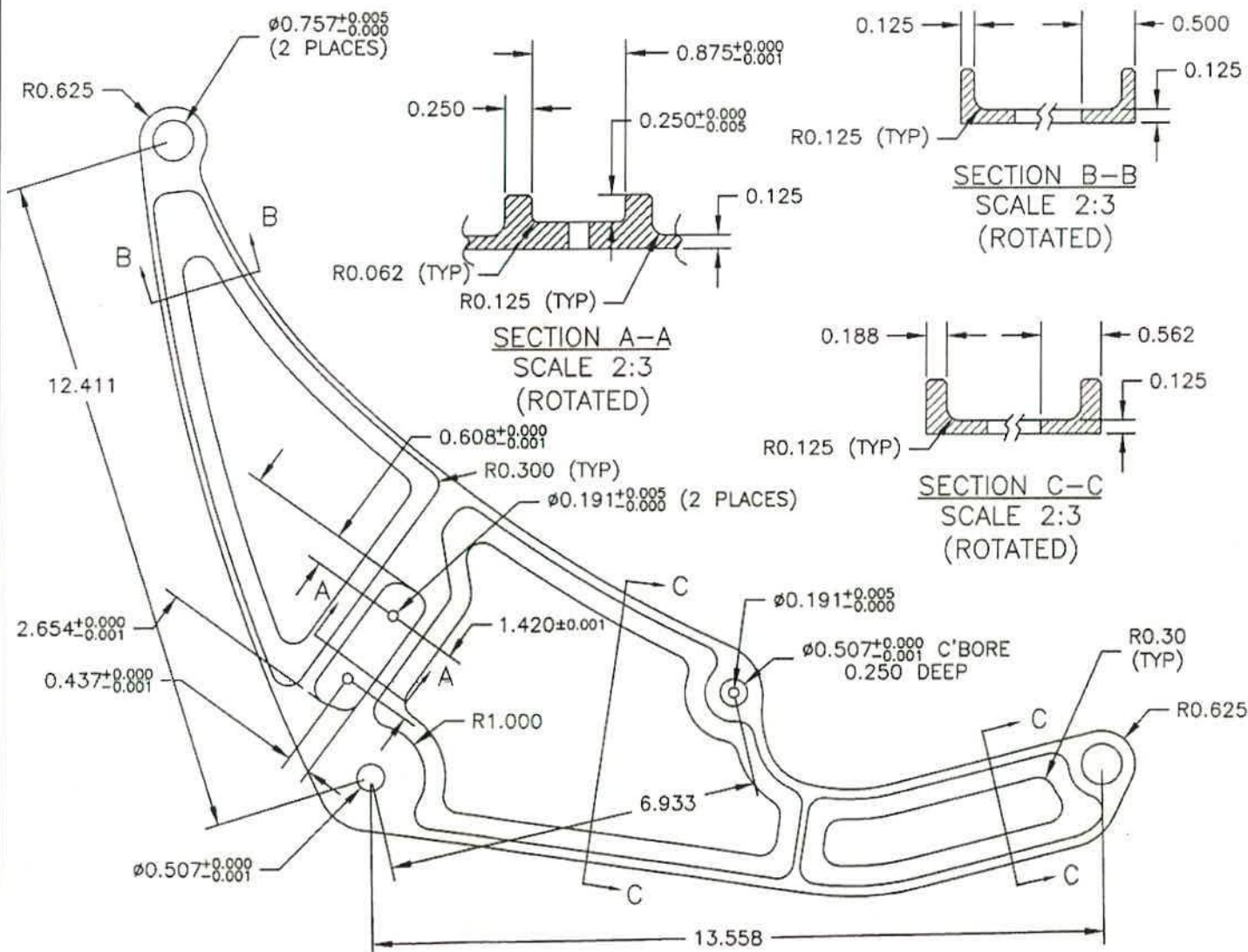
NOTE: Date & initial all entries

DART

| | | | |
|----------|----------|-----------------------------|--------------|
| DESIGN | DRAWN BY | DART AEROSPACE LTD | |
| CP | CP | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | APPROVED | DRAWING NO. | REV. B |
| | | D2803 | SHEET 1 OF 2 |
| DATE | | TITLE | SCALE |
| 04.11.22 | | STA 84 BRACKET | 1:3 |
| A | 00.11.07 | NEW ISSUE | |
| B | 04.11.22 | ADD CUTOUTS & -043/-044 | |

RELEASED

05-03 11

**D2803-1 BRACKET (SHOWN). D2803-2 BRACKET (OPPOSITE)**

- 1) MACHINE PER DRAWING FILE "D2803.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

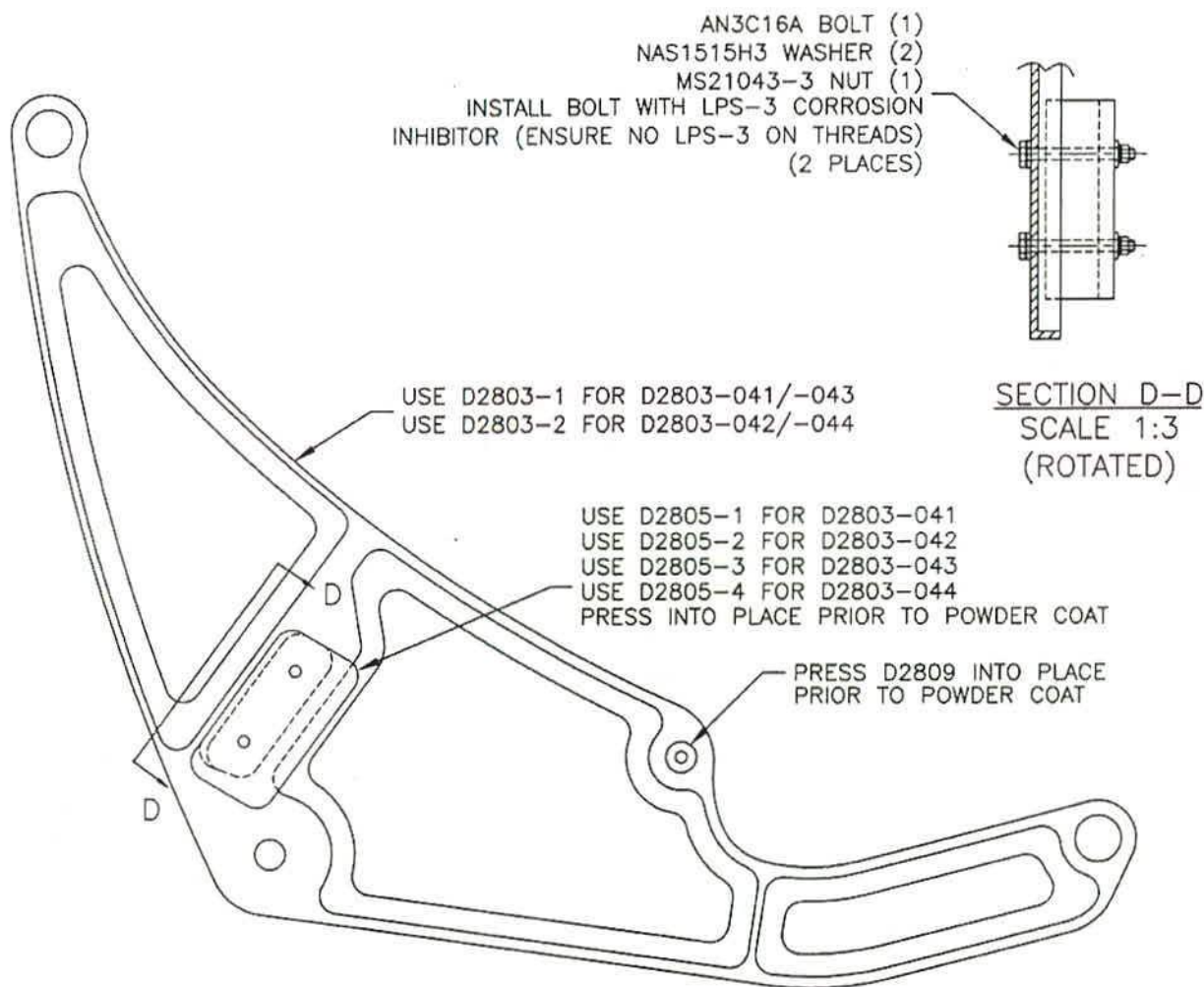
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WITHOUT NOTICE
WORK ORDER
NO. 33589

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| | | | |
|------------------|-------------------------|---|------------------------|
| DESIGN CP | DRAWN BY CP | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | APPROVED | DRAWING NO. D2803 | REV. B SHEET 2 OF 2 |
| DATE 04.11.22 | TITLE STA 84 BRACKET | | SCALE 1:3 |



RELEASED

05-03-11

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WITHOUT NOTICE

WORK ORDER

NO. 33589

D2803-041/-043 BRACKET ASS'Y (SHOWN).
D2803-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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